

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020557**Date Inspected:** 23-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Corporation, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shi Lei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Lift 12W and Lift12E**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Delbert Humphrey was present during the times noted above for observations relative to the work being performed at ZPMC.

OBG Bay # 16

WELDING

This QA observed the following components in this bay Steel Barriers W5-SB15-001, W5-SB15-002, W5-SB15-003. This QA observed no work being performed on the above mentioned components during the time QA was present. Barriers had been welded on one side and back gouged on other side.

OBG Bay #28

WELDING

This QA Inspector observed the following work in progress:

Holes were being slotted on Base plates, SP5-P-08-1 on Services Platform Handrails SP4, SP7, SP8.

OBG: (Trail Assembly)

WELDING

Lift 12E

This QA Inspector observed the following work in progress:

WELDING INSPECTION REPORT

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SMAW welding of weld joint OBE12-003 side panel, located on Lift 12E, identified as Welding Repair Report # B-CWR2126, welder is identified as 040378, ZPMC Quality Control (QC) is identified as Shi Lei. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G-(4F)-Repair and Critical Weld Repair # B-CWR2126

Lift 12W

SMAW welding of weld joint OBE12W-003, side panel, located on Lift12W, welder is identified as 040611, ZPMC Quality Control (QC) is identified as Zhou Pong. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Bu4-FCM-1.

SMAW welding of weld joint OBE12W-001, side panel, located on Lift12W, welder is identified as 0460611, ZPMC Quality Control (QC) is identified as Zhou Pong. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-Bu2-FCM-1.

OBG Bay # 8

NDT

The following NDT performed ZPMC NDT notification 08266:

This QA inspector performed MT testing on 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector Delbert Humphrey generated an UT report for this date. Time of inspection was 9:15 hours. The members are identified as follows OBG. The weld designations reviewed are as follow: BK004A3-062-025,026,051,052, BK004A-062-014, BK004A5-062-038~041, BK004A5-062-022, 023,042,043, BK004A6-062-029,030,115,116,031,032, BK004A7-062-085,086,165,166, BK004A7-062-085,086, 165,166, BK004A7-062-043,044,103,104, BK004A7-062-013,014,019,020, BK004A7-062-007,008, BK004A7-062-222,227,223,226, BK004A7-062-145,160, BK004A8-062-029,030, BK004A8-062-019~022,115, 116,031,032.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Humphrey, Delbert
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Quality Assurance Inspector

Reviewed By:	Hall, Steven
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QA Reviewer
